

shp uled July 6

Work Order ID 71401



~~PRELIMINARY ISSUE~~

Page 1

Thursday, June 30, 2011 3:20:07 PM

Item ID: D4423-1	Accept		Setup	Start	
Revision ID: PRELIM					
Item Name: Splash Guard Extension				Stop	
Start Date: 6/30/2011	Start Qty: 1.00				
Required Date: 7/8/2011	Req'd Qty: 1.00				
Reference:					

Cust Item ID:
Customer:



Approvals:	Process Plan:	Date: <u>7/6/11</u>	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4423	PA1								
100	FLOW WATER JET	0.00							
	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
6061 - 035	1-Cut as per Dwg D4423								
	Dwg Rev: PA1								
	Prog rev: PA1								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

B11-7-5

③

B11-7-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71401

Thursday, June 30, 2011 3:20:07 PM



Page 2

Item ID: D4423-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Splash Guard Extension

Start Date: 6/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

- inspector to PA1

0.00

Dwg only
8/10/15 (x3)

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3065

0.00

0.00

SB 11/10/15

(3)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

- inspector to PA1

0.00

Dwg only
8/10/16 (x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71401

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Page 3

Item ID:	D4423-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Splash Guard Extension					
Start Date:	6/30/2011	Start Qty:	1.00			
Required Date:	7/8/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				3	0	16-7-6	
	Hand Finishing								

165	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
	Powdercoat	0.00				3X	0	14/07/06	
	Powder Coating								

170	QC3- Inspect Part Finish	0.00							
	QC	0.00						19 11/7/6 (3)	
	Quality Control								

M115128

Start Time: 11:50
Temp: 320°F
Finish Time: 12:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


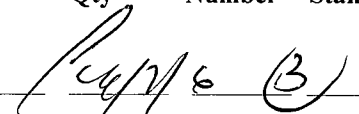

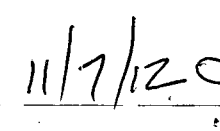
Work Order ID 71401

Thursday, June 30, 2011 3:20:07 PM


Page 4

Item ID: D4423-1 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Splash Guard Extension
Start Date: 6/30/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 7/8/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
190  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/7/12 
Quality Control									MEF 11-07-07

POSITIVE RECALL

EFFECTIVE  AUTH RELEASED  DATE 11.07.02

POZ - REV. A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 30, 2011 3:20:13 PM

Page 1

Work Order ID: 71401

Parent Item: D4423-1

Parent Item Name: Splash Guard Extension



Start Date: 6/30/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No				sf	102.5000		0.471684			
6061-T6 Sheet 0.032"													



B11-3-5

Location

Loc Qty

Loc Code

MAT021

102.5

110063

1

118106

96

16954

5.5

16954

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 71401
Description: SPLASH GUARD EXTENSION	Part Number: DL423-1
Inspection Dwg: DL423-1, Rev: PA1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

X

Prototype

[illegible]

Measured by: B	Audited by: S	Prototype Approval:
Date: 11-7-8	Date: 11/02/05	Date:

to PA1 Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order: 71401
Description: SPLAS GAUZE extension	Part Number: D4423-1 (Bent)
Inspection Dwg: D4423 Rev: P171	Page 1 of 1

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	SP'	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	11/07/06	Date:	11/07/06	Date:	N/A

to 12/24/09

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

D

C

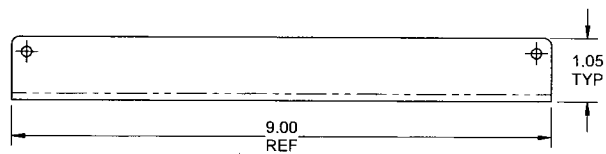
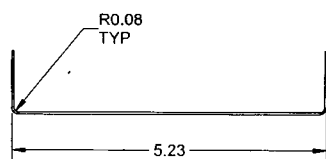
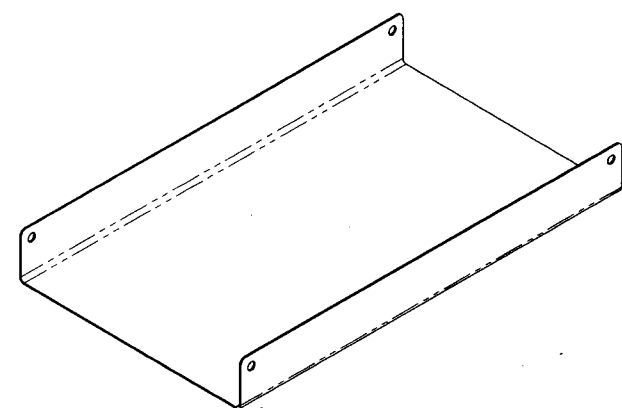
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A

A



D4423-1 SPLASH GUARD EXTENSION

WLO 71401

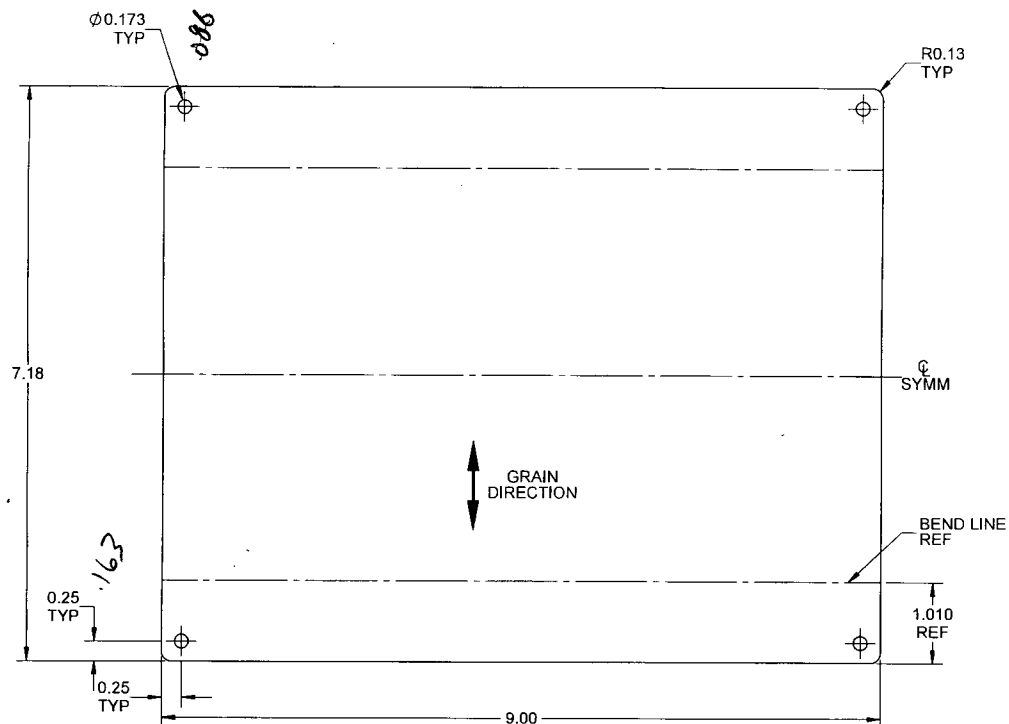
PRELIMINARY ISSUE

11.06.22

- NOTES:**
- 1) MATERIAL: MAKE FROM D4423-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4423-1" AND B/N PER QSI 044 6.1
 - 7) WEIGHT: 0.20 lbs

PA1	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4423	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD EXTENSION	NTS
DATE	11.06.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



D4423-1F SPLASH GUARD EXTENSION FLAT PATTERN

PRELIMINARY ISSUE

11.06.22

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4423	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD EXTENSION	NTS
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8 7 6 5 4 3 2 1

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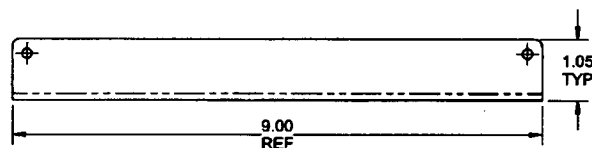
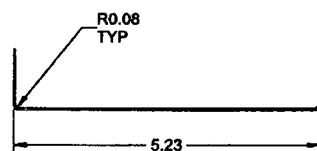
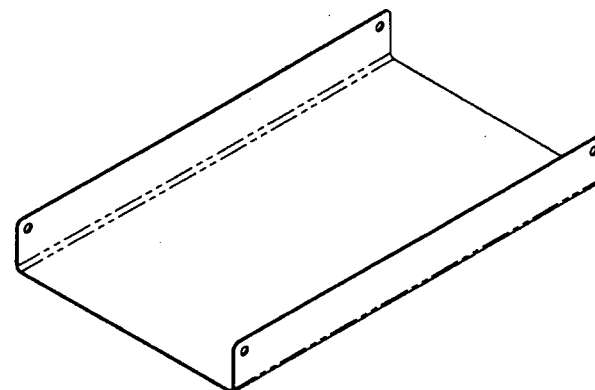
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A

A



D4423-1 SPLASH GUARD EXTENSION

71401

RELEASED
2011-07-06

NOTES:

- 1) MATERIAL: MAKE FROM D4423-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4423-1" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

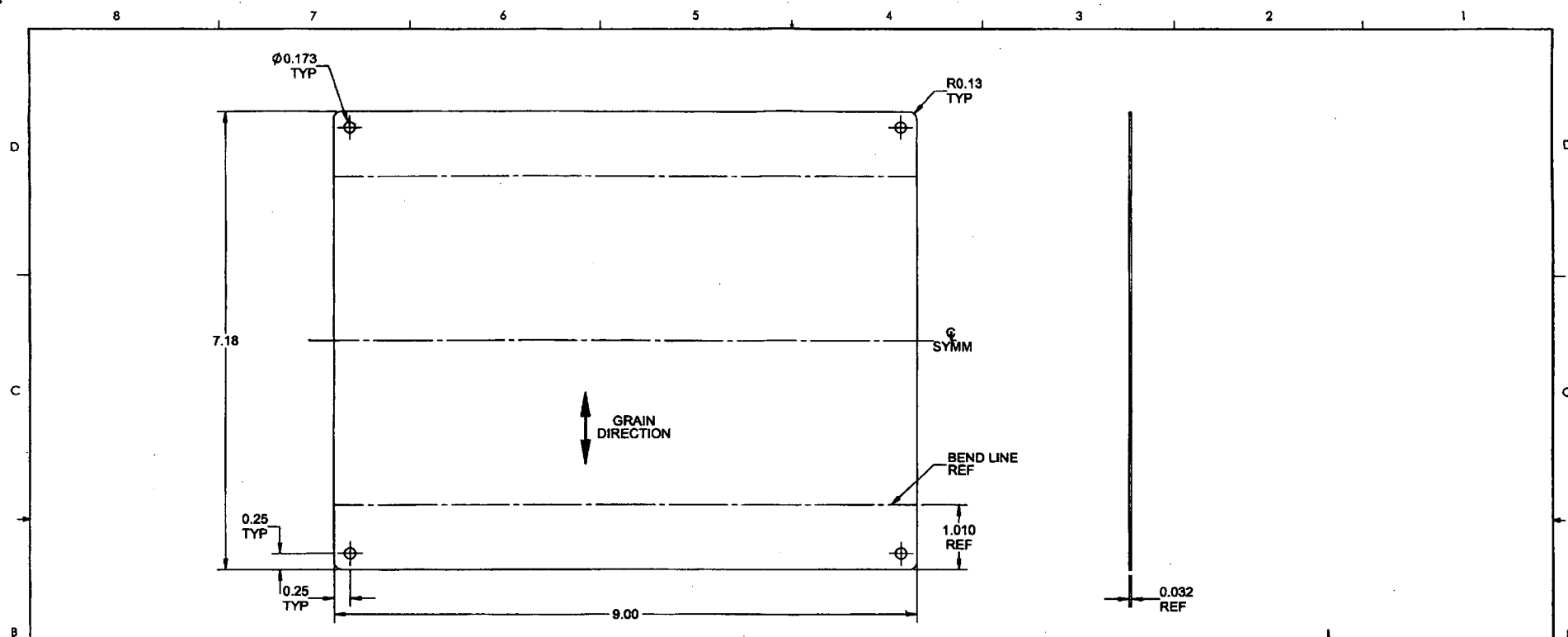
REV.	NEW ISSUE	DESCRIPTION	MB	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	11.06.22			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4423** REV. A
SHEET 1 OF 2
TITLE **SPLASH GUARD EXTENSION** SCALE **NTS**

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8 7 6 5 4 3 2 1



D4423-1F SPLASH GUARD EXTENSION FLAT PATTERN

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4423	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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2011-07-06

71401